

Work Order ID 83454***83454***

Page 1

Wednesday, April 18, 2012 8:43:37 AM

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft Out 205
Start Date: 4/18/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/25/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/04/10 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2573	Rev E								

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No. 83454 Double check by: ET 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-
Machine Step No 3 per Folio FA051 and insp

B.A 12/05/10

6

φ

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2573 & D2574

B.A 12/05/10

6

φ

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B.A 12/05/10

6

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83454

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83454

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Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 4/18/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:00 FINISH TIME: 9:30	0.00 0.00				6X	0		

M121134

32001

9:30

⑥ 125-14

M/L

6X 0 12/05/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83454

Wednesday, April 18, 2012 8:43:37 AM

83454

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Item ID: D2573

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft Out 205

Start Date: 4/18/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6 0 125-H.

170

Identify as per dwg & Stock Location: ST 433 0.00***170***

Packaging

Memo

0.00

Packaging

6 0 SAC 12-5-14

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/15 ME
12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 18, 2012 8:43:41 AM

Page 1

Work Order ID: 83454

83454

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 4/18/2012

Required Date: 4/25/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	44.0000	1	6			

D6101-007

**

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

44

→ 79875

16

81994

28

6 on 12/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 83454
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.441	0.441	0.441	0.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.503	0.503	0.500	0.500		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.503	0.502	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.561	0.569	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.123	0.123	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.241	0.240	0.240		
W	0.115	0.135		0.124	0.124	0.123	0.124		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.365	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.249	0.249	0.248		
AE	1.500	1.520		1.515	1.516	1.514	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.280	0.280	0.280	0.280		
AH	0.240	0.260		0.251	0.252	0.251	0.251		
AI	2.000	2.020		2.0018	2.0015	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: H.A.
Date: 12/05/10

Audited by: [Signature]
Date: 12/05/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order: 83454
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	1	1		
A	0.438	0.443		0.441	0.441				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		0.500	0.500				
G	0.257	0.262		0.259	0.259				
H	0.375	0.380		0.377	0.377				
I	0.490	0.510		0.502	0.502				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.570	0.570				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		0.126	0.126				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.124	0.123				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		0.240	0.240				
W	0.115	0.135		0.132	0.132				
X	0.308	0.313		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.362	0.364				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.627	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.249	0.249				
AE	1.500	1.520		1.512	1.514				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.280	0.280				
AH	0.240	0.260		0.251	0.251				
AI	2.000	2.020		2.0015	2.001				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by: B.A.
Date: 12/05/11

Audited by: [Signature]
Date: 12/05/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

